

Date: Thursday, 4/5/2007 11:58:53 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 31689		
Estimate Number	: 10195		
P.O. Number	: N/A	Part Number	: D21741
This Issue	: 4/5/2007 S.O. No. : N/A	Drawing Number	: D2174-1 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: 30870	Material	: N/A
Written By	:	Due Date	: 4/30/2007
Checked & Approved By	:	Qty:	36 Um: Each
Comment	: Est C 04/06/09 Reformat KJ/RF		
	Est Rev:D As per Rev E 06-11-22 JLM		

Additional Product

Job Number: 516



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 0.4958 sf(s)/Unit Total : 14.8743 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)

Batch: M103321

SAD 07/05/17

36

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2174

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

SAD 07/05/17

36

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/17

36

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07/05/22 36
 count

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

MF 07-05-23

36

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/5/2007 11:58:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 31689

Part Number: D21741

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/23 (36)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL/BR

07/05/24 (36)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

PC 7/5/24 (36)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/5/24 36

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/24 (36)

Job Completion



U 07/05/24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31689
Description: Web		Part Number:	D2174-1
Inspection Dwg: D2174	Rev: E	Page 1 of 1	

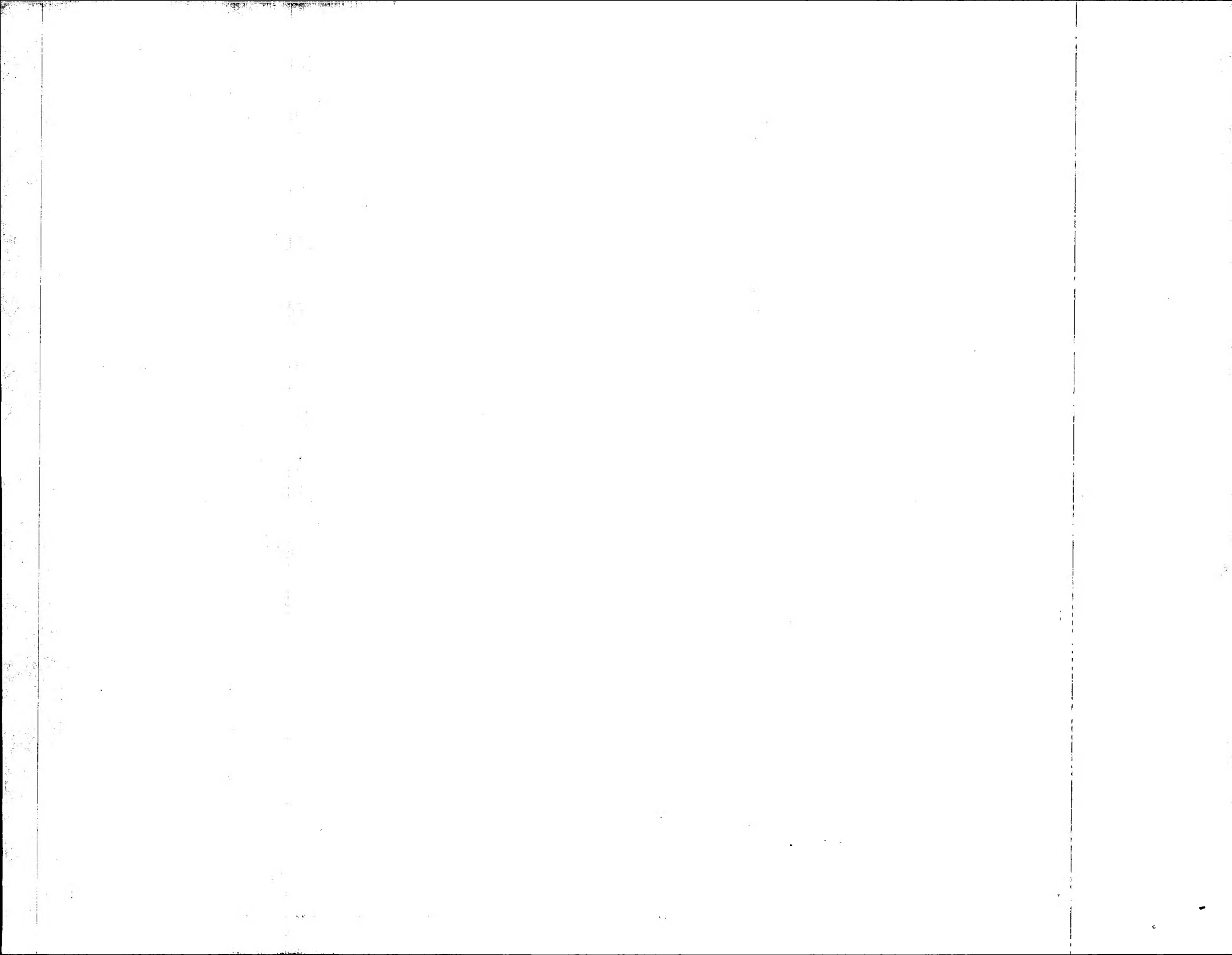
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.250	+/-0.010	6.258	✓		Vern	
6.400	+/-0.010	6.400	✓		Vern	
4.800	+/-0.010	4.806	✓		Vern	
1.375	+/-0.010	1.383	✓		Vern	
1.050	+/-0.005	1.048	✓		Vern	
Ø0.128	+0.005/-0.001	Ø0.129	✓		Vern	
12.650	+/-0.010	12.650	✓		M-T	
0.550	+/-0.010	0.550	✓		Vern	
0.900	+/-0.010	0.906	✓		height gauge	
1.629	+/-0.010	1.633	✓		Vern	
1.506	+/-0.005	1.507	✓		Vern	
11.550	+/-0.005	11.547	✓		Vern	
50°	+/-0.5°	50°	✓		Angle	
0.063 thick	+/-0.010	0.063	✓		Vern	
Ø0.172	+0.005/-0.001	Ø0.174	✓		Vern	
0.063	+/-0.010	0.061	✓		Vern	

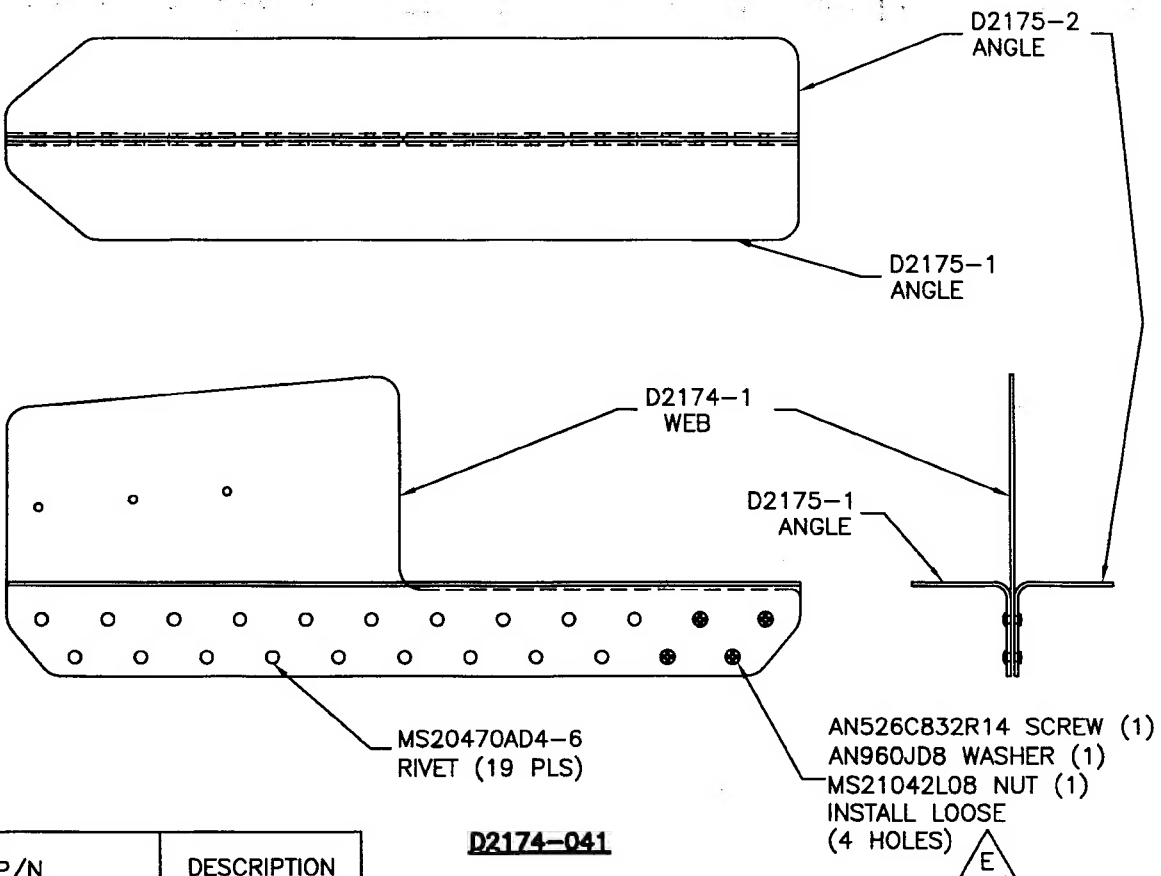
Measured by:	SAD	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	07/05/17	Date:	07-05-22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.04.02	Ø0.172 dimension added	KJ/JLM	[Signature]





DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
RF	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED CH	DRAWING NO. D2174	SHEET 1 OF 2
DATE 06.09.25	TITLE WEB ASSEMBLY	SCALE 1:3	
A	95.10.25	NEW ISSUE	
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC.	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE	



D2174-041

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 31689
WORK ORDER

RELEASED
06.10.13

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

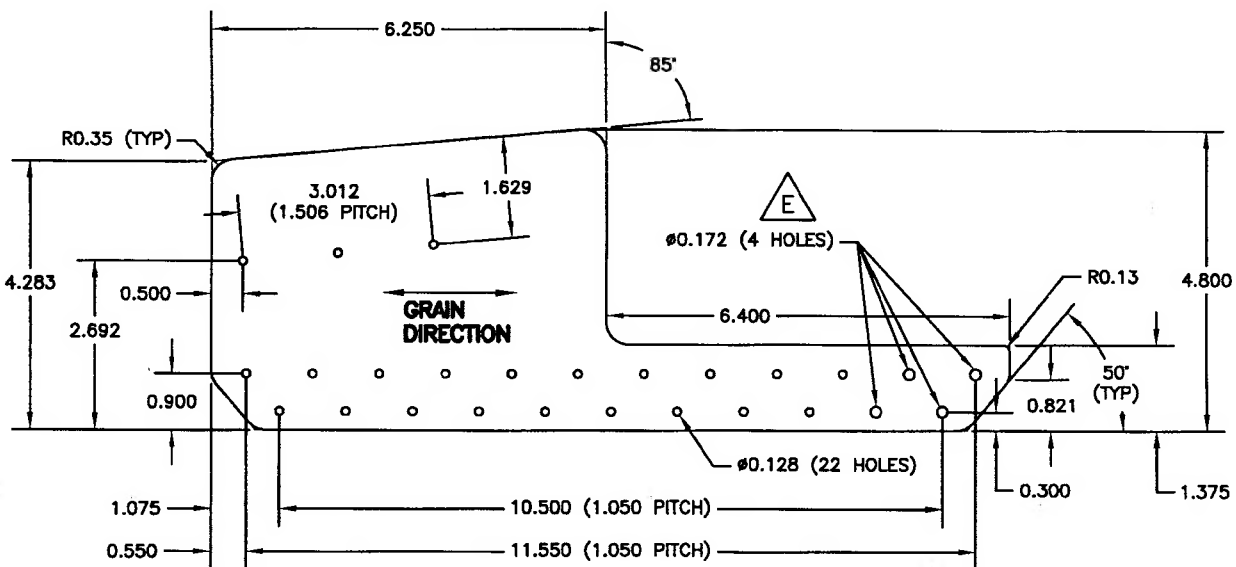
NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.



DESIGN		DRAWN BY		DART AEROSPACE LTD	
RF		CE		HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. E	
PH	[Signature]	D2174		SHEET 2 OF 2	
DATE		TITLE		SCALE	
06.09.25		WEB		1:3	

RELEASE
06-10-63



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) ALL DIMENSION ARE IN INCHES

NO. 31687 WORK ORDER 31687

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